

Date: Thursday, 04/12/2008 9:10:53 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : PANEL
 Job Number : 43902
 Estimate Number : 10872
 P.O. Number :
 This Issue : 04/12/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D32452
 First Issue : / / Type : SMALL / MED FAB Drawing Number : D3245 REVB
 Previous Run : 36401 Project Number : N/A
 Material :
 Due Date : 20/12/2008 Qty: 6 Um: Each
 Written By :
 Checked & Approved By : JUD 08-12-04
 Comment : Est. A 04.07.07 New issue KJ/JLM
 Est Rev:b ECN 1052 07-10-31 DD verified by:

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S22GA 304/316 .032 Sheet



Comment: Qty.: 0.8442 sf(s)/Unit Total : 5.0652 sf(s)

304/316 .032 Sheet

Batch: 109057 IB 8-12-16

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3245 ****prog.D3245-1/-2****

Dwg Rev: B

Prog Rev: B

IB 8-12-16

(8)

2-Deburr if necessary

IB 8-12-16

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



IB 8-12-16

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

8 08/12/16 (8)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Deburr if necessary

C'sink as per Dwg D3245

Form D3245-1 as per Dwg D3245/Identify as D3245-1

8 09/02/27 (8)

SB 09/02/25 (8)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____



Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

Date: Thursday, 04/12/2008 9:10:53 AM
User: Julie Dawson

Process Sheet

| | | | |
|---|---|--|--|
| Customer: CU-DAR001 Dart Helicopters Services | | Drawing Name: PANEL | |
| Job Number: 43902 | | Part Number: D32452 | |
| Job Number: | |  | |
| Seq. #: | Machine Or Operation: | Description : | |
| 6.0 | QC5 | INSPECT WORK TO CURRENT STEP | |
| |  |  | |
| Comment: INSPECT WORK TO CURRENT STEP | | 09/03/02  | |
| 7.0 | PACKAGING 1 | PACKAGING RESOURCE #1 | |
| |  |  | |
| Comment: PACKAGING RESOURCE #1 | | 09/03/02  | |
| Identify and Stock Location: 1R 1R | | | |
| 8.0 | QC21 | FINAL INSPECTION/W/O RELEASE | |
| |  |  | |
| Comment: FINAL INSPECTION/W/O RELEASE | | 09/03/02  | |
| Job Completion | |  | |
| | | ME 09-03-02 | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

| | | |
|------------------------------|---------------|-----------------------------|
| DART AEROSPACE LTD | | Work Order: 43902 |
| Description: Doubler | | Part Number: D3245-2 |
| Inspection Dwg: D3245 | Rev: B | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø0.098 | +0.004/-0.001 | .100 | X | | | |
| Ø0.375 | +0.006/-0.001 | .378 | X | | | |
| 0.400 | +/-0.010 | .401 | X | | | |
| 1.117 | +/-0.010 | 1.120 | X | | | |
| 1.150 | +/-0.010 | 1.152 | X | | | |
| 1.000 | +/-0.010 | .999 | X | | | |
| 10.57 | +/-0.030 | 10.575 | X | | | |
| 9.500 | +/-0.010 | 9.503 | X | | | |
| 8.350 | +/-0.010 | 8.344 | X | | | |
| 3.500 | +/-0.010 | 3.501 | X | | | |
| 9.40 | +/-0.030 | 9.400 | X | | | |
| 11.04 | +/-0.030 | 11.042 | X | | | |
| 6.200 | +/-0.010 | 6.197 | X | | | |
| 2.230 | +/-0.010 | 2.237 | X | | | |
| 2.020 | +/-0.010 | 2.026 | X | | | |
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|------------------------|-----------------------|----------------------------|-----|
| Measured by: IE | Audited by: S | Prototype Approval: | N/A |
| Date: 8-12-16 | Date: 08/12/16 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 08.09.04 | New Issue | KJ/DD | DD |

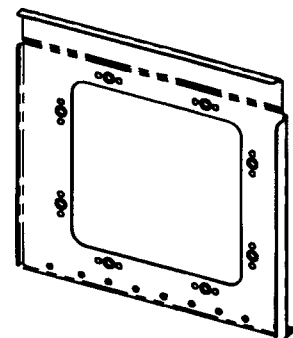
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

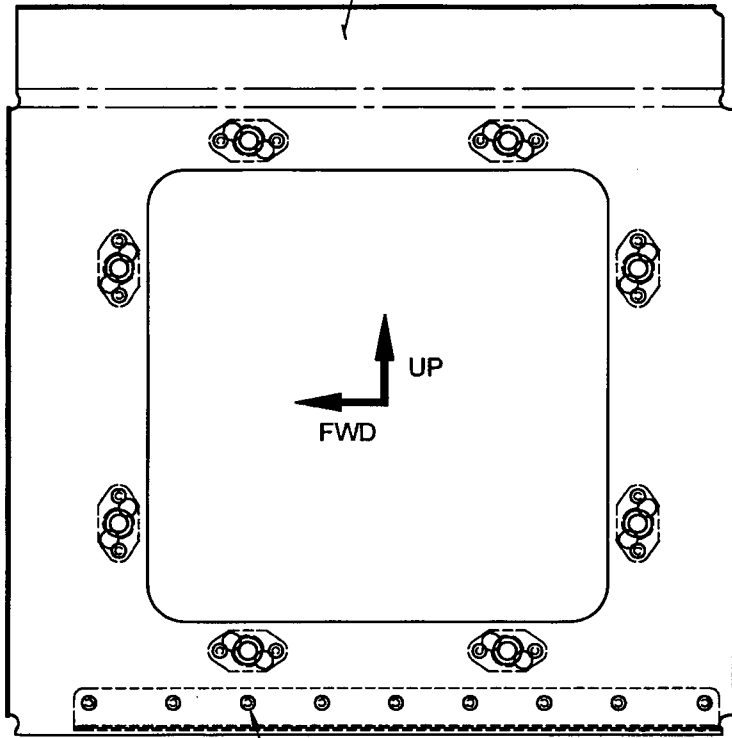
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



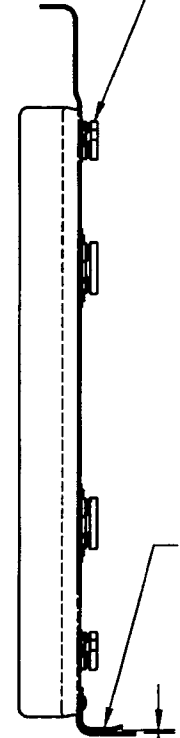
D3245-1
PANEL

2350-18-C3Y DZUS
RIGID RECEPTACLE (1)
MS20427M3-3 RIVET (2)
(8 PLACES)



MS20615M3-3 RIVET
(9 PLACES)

D3245-041 ACCESS PANEL ASSEMBLY

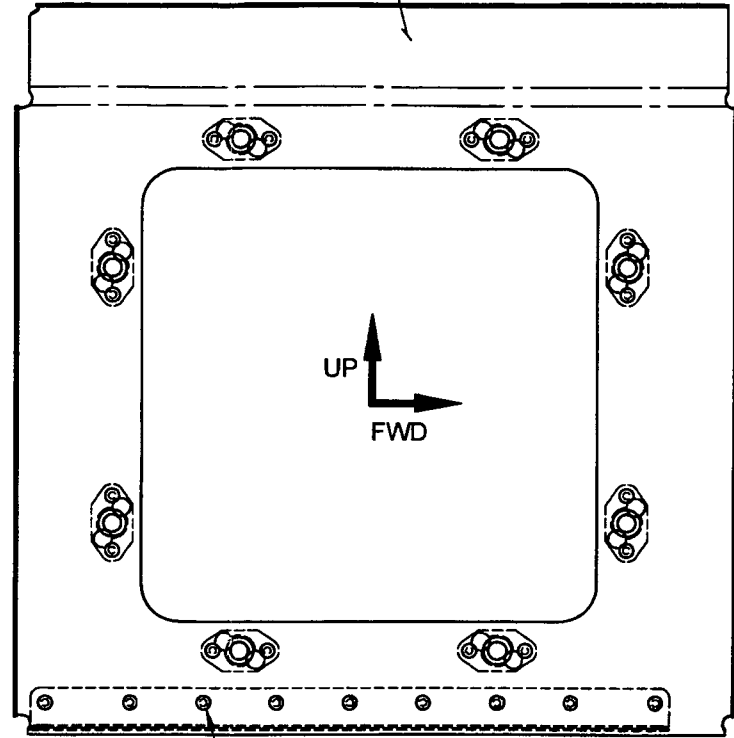
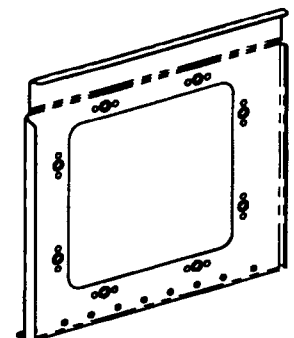


D3245-5
ANGLE PLATE

0.032
GAP

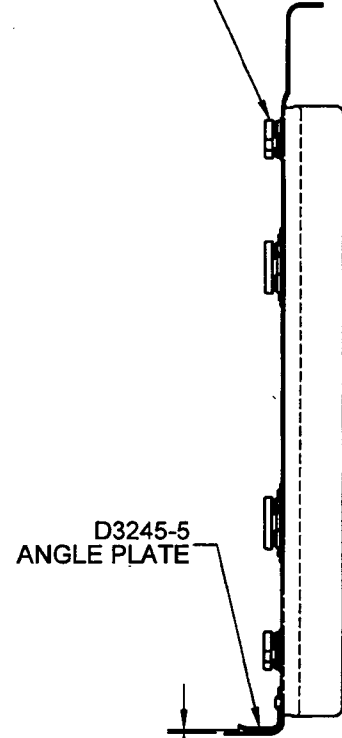
2350-18-C3Y DZUS
RIGID RECEPTACLE (1)
MS20427M3-3 RIVET (2)
(8 PLACES)

D3245-2
PANEL



MS20615M3-3 RIVET
(9 PLACES)

D3245-042 ACCESS PANEL ASSEMBLY



D3245-5
ANGLE PLATE

0.032
GAP

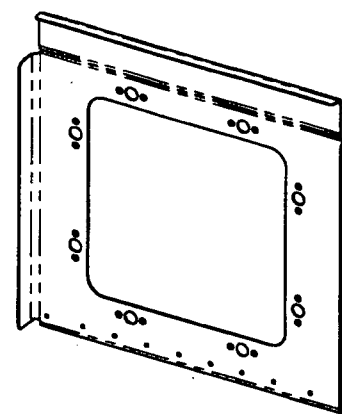
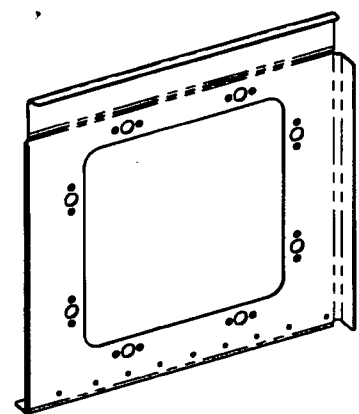
| QTY -041 | QTY -042 | P/N | DESCRIPTION |
|-------------|-------------|-------------|---------------------------|
| X | | D3245-041 | ACCESS PANEL ASSEMBLY, LH |
| | X | D3245-042 | ACCESS PANEL ASSEMBLY, RH |
| 1 | | D3245-1 | PANEL |
| | 1 | D3245-2 | PANEL |
| 1 | 1 | D3245-5 | ANGLE PLATE |
| 8 | 8 | 2350-18-C3Y | DZUS RIGID RECEPTACLE |
| 16 | 16 | MS20427M3-3 | RIVET |
| 9 | 9 | MS20615M3-3 | RIVET |

RELEASED
07.10.02

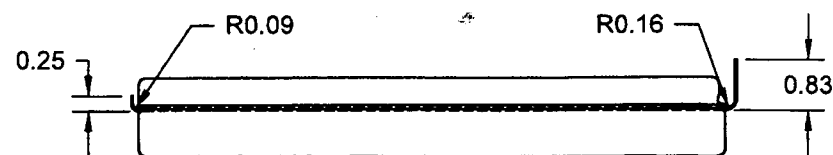
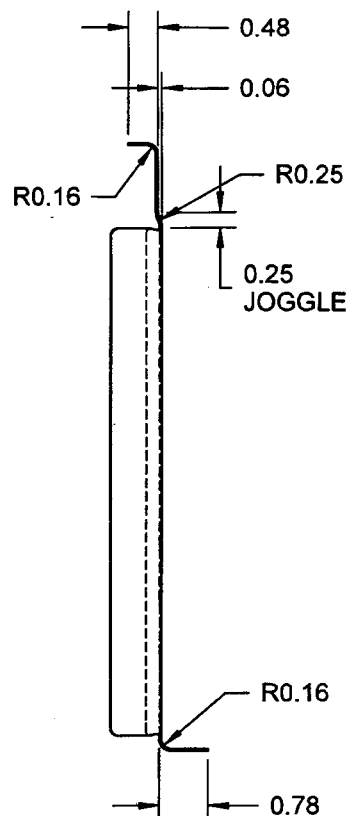
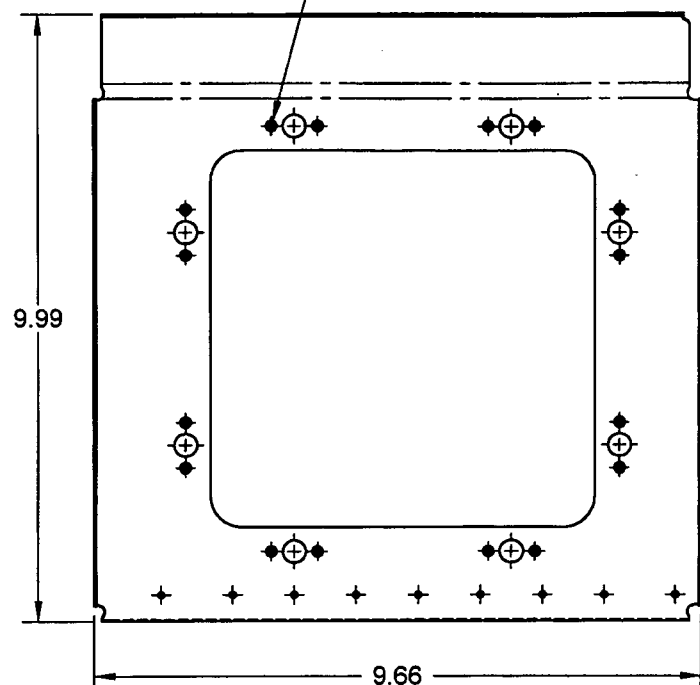
- NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.83 lbs

| | | | |
|------------|---|--|--------------|
| B | REMOVE Ø0.204 HOLES FROM D3245-1/-1F, REMOVE MS21060-L3K NUTPLATES & DURABLE BLACK GASKETS FROM D3245-041/-042: HOLES AND ITEMS ARE NOW PART OF INSTALLATION. ASSIGN P/Ns TO GASKETS & REFORMAT DRAWING | MB | 07.10.02 |
| A | NEW ISSUE | RF | 04.01.27 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | PH | DRAWING NO. | REV. B |
| CHECKED | PH | D3245 | SHEET 1 OF 7 |
| MFG. APPR. | PH | TITLE | SCALE |
| APPROVED | PH | ACCESS PANEL ASSEMBLY | 1:2.5 |
| DE APPR. | PH | COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |
| DATE | 07.10.02 | | |

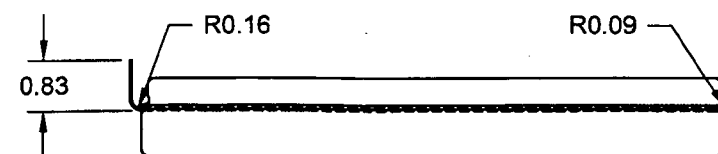
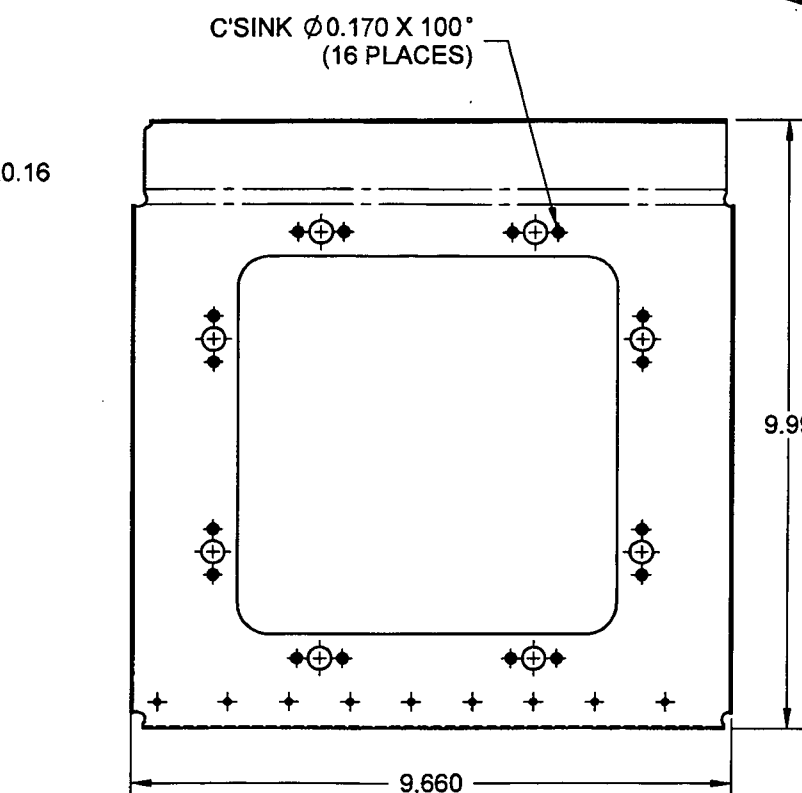
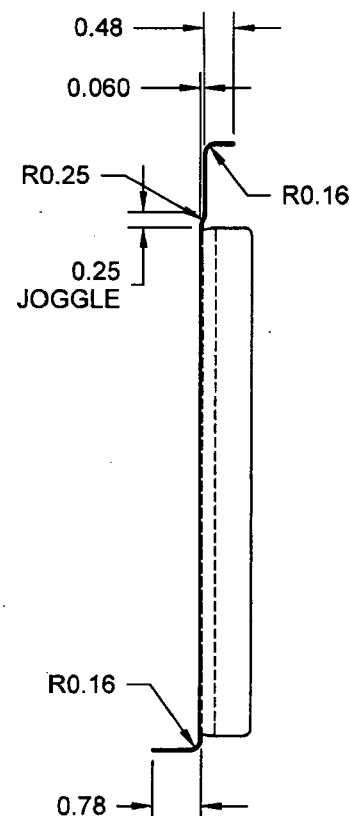
SHOP COPY B
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 45902



C'SINK $\varnothing 0.170 \times 100^\circ$
(16 PLACES)



D3245-1 PANEL BEND DETAIL, LH



D3245-2 PANEL BEND DETAIL, RH

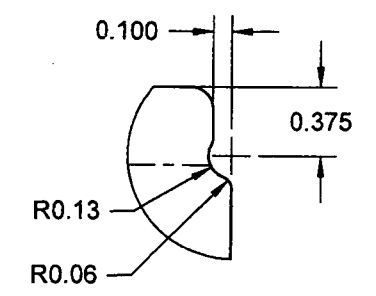
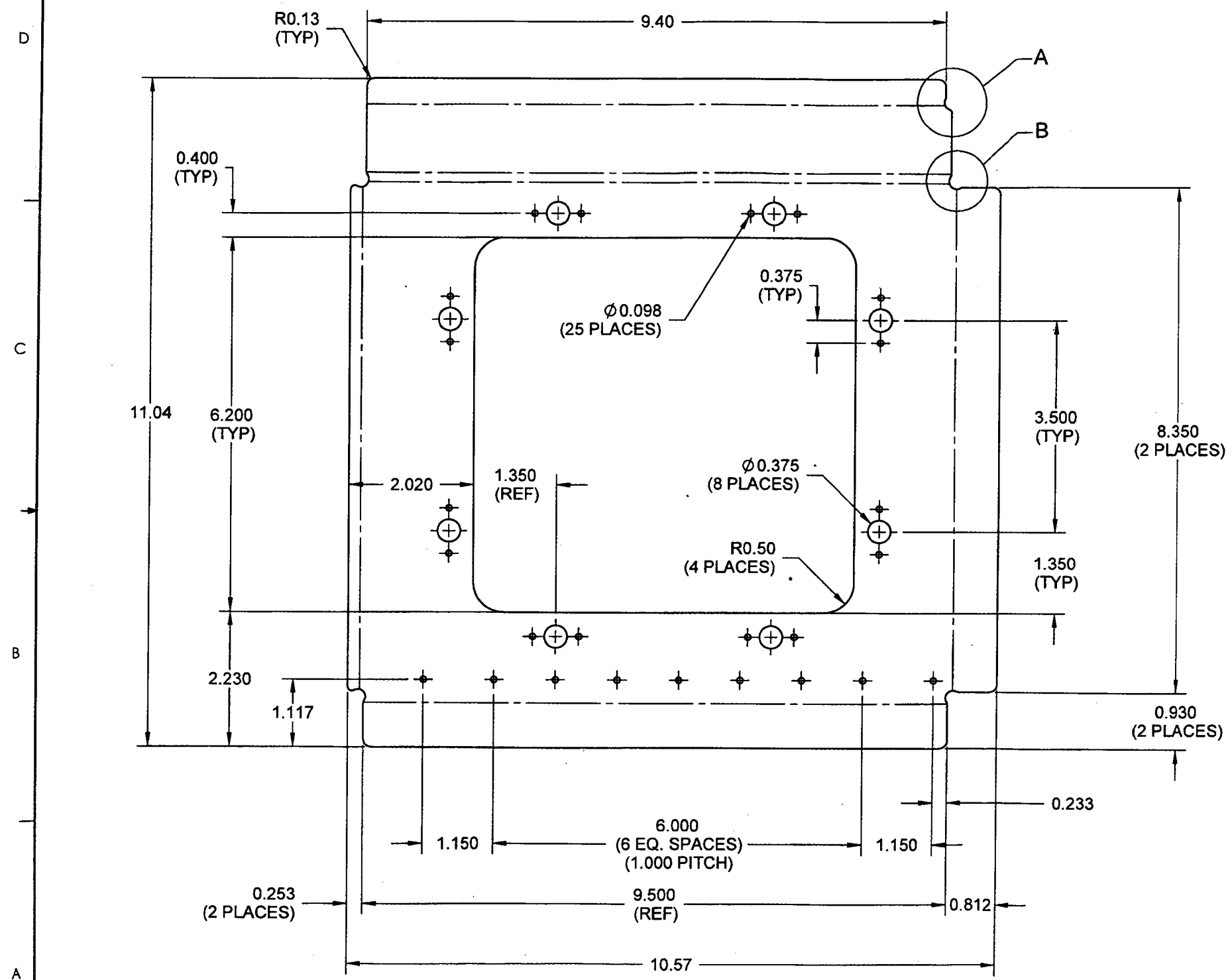
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43902

RELEASED
WP 07-10-23

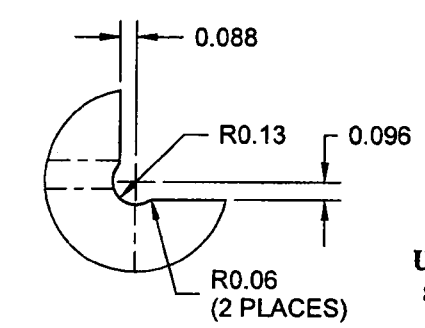
- NOTES:
1) MATERIAL: MAKE FROM D3245-1F
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 0.70 lbs

| | | | |
|------------|----------|--|--------------|
| DESIGN | JH | DART AEROSPACE LTD | |
| DRAWN | JH | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | PH | DRAWING NO. | REV. B |
| MFG. APPR. | DS | D3245 | SHEET 2 OF 7 |
| APPROVED | MD | TITLE | SCALE |
| DE APPR. | JH | ACCESS PANEL ASSEMBLY | 1:3 |
| DATE | 07.10.02 | COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

8 7 6 5 4 3 2 1



DETAIL A: RELIEF
SCALE 1:1



DETAIL B: RELIEF
(TYP. 4 PLACES)
SCALE 1:1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENTS
WITHOUT NOTICE
WORK ORDER NO. 43902

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET
(0.032 THICK, REF)
PER MIL-S-5019 (ANNEALED) 2B FINISH
(REF. DART SPEC. M304S22GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.70 lbs

RELEASED
11/01/02

D3245-1F PANEL FLAT PATTERN

| | | | |
|------------|----------------|---|--------------|
| DESIGN | 7# | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | PH | DRAWING NO. | REV. B |
| MFG. APPR. | | D3245 | SHEET 4 OF 7 |
| APPROVED | 140 | TITLE | SCALE |
| DE APPR. | | ACCESS PANEL ASSEMBLY | 1:2 |
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8 7 6 5 4 3

